

Work Order ID 58726

Tuesday, May 18, 2010 8:03:40 AM



Page 1

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 5/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*RF*Date: *10-5-18* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 ☐ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary*10-5-19**(9)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-5-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8.10.15.120**(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Window

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Start Date: 5/17/2010 **Start Qty:** 6.00

**Cust Item ID:**

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Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



**Insp.
Stamp**

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin □ remove sharp edge by degurring.

Pl. 10/05/20
x9

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 ☐ Dwg.
Rev. C ☐ Folio Rev B ☐ 2-Engrave part# &
batch#, ☐ (D3290-3)

10/05/25
x9

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/ 10/05/25
x9

W/O:		WORK ORDER CHANGES					
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Work Order ID 58726

Tuesday, May 18, 2010 8:03:40 AM

Page 3

Item ID: D3290-3

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Start Date: 5/17/2010 Start Qty: 6.00

Required Date: 5/21/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

x9
10/05/25

170 HAND FINISHING THERMOFORMING 0.00



Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches if required

x9
10/05/25

180 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

5/10/25

x9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58726

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Page 4

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 5/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 221

0.00



Packaging

Memo

0.00

Packaging

10-5-2794

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01 MF 10-5-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 18, 2010 8:03:43 AM

Page 1

Work Order ID: 58726



Parent Item: D3290-3



Parent Item Name: Window

Start Date: 5/17/2010

Required Date: 5/21/2010

Comments:

IPP A 04.08.18 New issue KJ/RF

IPP B 06.05.09 Ecn 798 EC

IPP C 07.05.29 Thermoform in-house DL

IPP D 07.09.28 rev C dwg EC verified by: DD

Start Qty: 6.00

Required Qty: 6.00

MACRLICS.125

Purchased

No

100

sf

90.2722

3



1810-5-19

1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT

90.2722

113204

4

113861

10.4

114673

75.8722

114673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58726
Description: Window		Part Number:	D3290-3
Inspection Dwg: D3290 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.58	+/-0.030	26.58	✓			
16.08	+/-0.030	16.08	✓			
13.79	+/-0.030	13.79	✓			
12.40	+/-0.030	12.40	✓			
8.81	+/-0.030	8.81	✓			

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 10-5-19	Date: 10/5/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

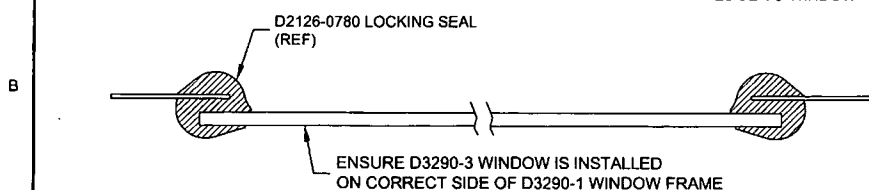
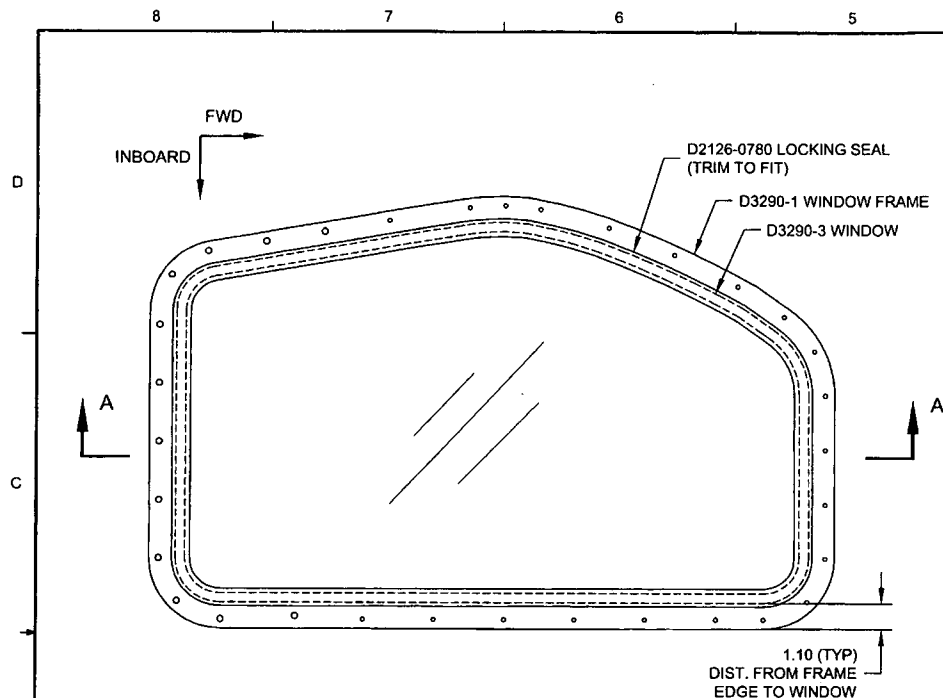
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

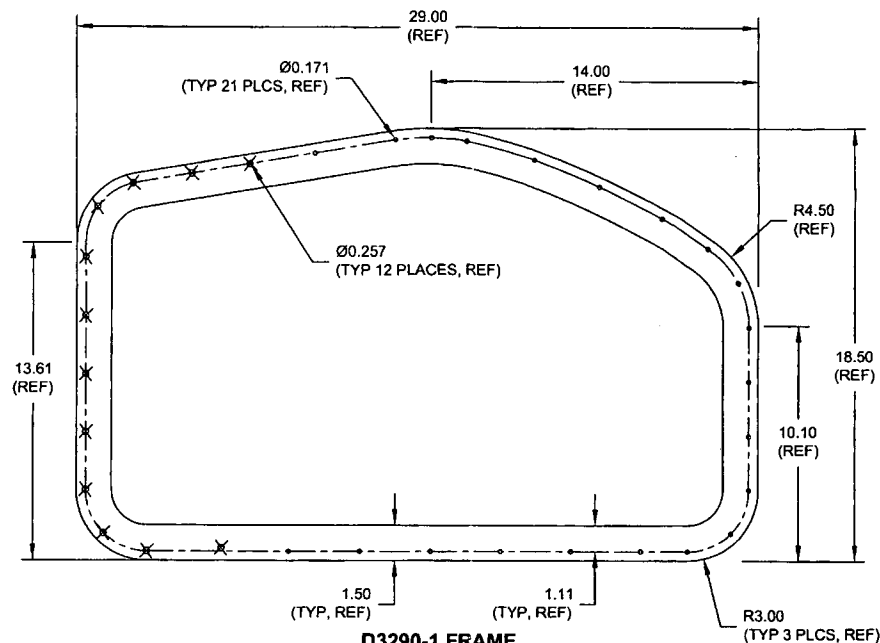
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 58724

B310-5-18



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3290 TITLE REPLACEMENT WINDOW ASSEMBLY SCALE 1:5 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

UNDER REVIEW

4/07/07-18
7/15/09-05
6/1/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

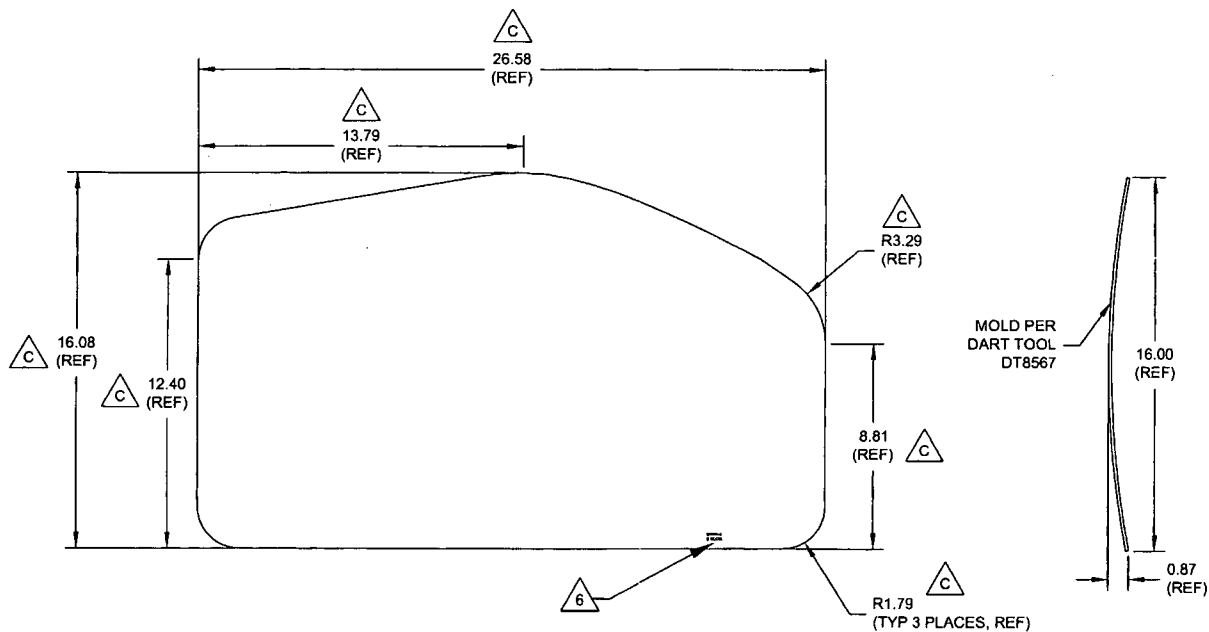
A

D

C

B

A



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

WPA/10/179
UNDER REVIEW
DEO ATTACHED
RELEASED
 07.09.22 #

SHOP
 RETURN
 ENGINEER
 CONTROLLED
 AMENDMENT
 NOTICE
 DER
 NO 58724

DESIGN	3F	DART AEROSPACE LTD	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. C
MFG. APPR.	JE	D3290	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>JP</i>	MFG. APPR. <i>FE</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

W/058726

RELEASED
 2009 -10- 09
WJ

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